



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T102137-107-109**Job Sheet 197837****Part No:** RB T102137-107-109**Job Qty:** 15 pcs**Part Name:** Clevis**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/17/19**Job Tracking No:****Due Date:** 8/30/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG RB T102137-107 RevG IPP Rev A 17.12.07 New issue DP Verify DD/IPP Rev. B 19.06.07 Material change DP Verify DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	15 pcs	8/30/19	8/30/19	0.00	0.60	Bandsaw - 1		ALA.
110	NV5000 - 1 - B4B	15 pcs	8/30/19	8/30/19	1.00	15.00	NV5000 - 1 - B4B		ALA.
							NV5000 - 2 - B4B		
120	QC 2	15 pcs	8/30/19	8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

19/8/8
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19/8/8



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S203789**Part:** RB T102137-107-109**Job No:** 197837**Serial No/Batch:** S203789**Revision:** G**Inspector:****Exp Date:****Instructions:**

Date: 08/08/19

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					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130 QC 8	15 pcs	8/30/19	0.00 0.00		QC 8 - 12	219/08/19
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
141 Outsource - 1 - Heat Treat	15 pcs	8/30/19			-ME1001-VC	ATL 002 2019-08-21
142 Packaging 2-1 - Receive - B4B	15 pcs 14	8/30/19	0.00 0.00		Packaging 2 - 1 - B4B	AUG 29 2019
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
143	QC 6	15	8/30/19	0.00 0.00	QC 6 - 9
				pcs	QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
180	Packaging 3-1 - Stock - B4B	15	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B
				pcs	Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
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					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	15 pcs	8/30/19	0.00	0.00	QC 21 - SA - 21	DWG 21
					QC 21 - SA - 70	21
					QC 21 - SA - 53	53

SEP 03 2019

GA152A

Part Op 100 - Bandsaw - Cut blanks to 3.625"

Descriptions: 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) - 1-Machine as per folio FB846 FOLIO REV: AA

DWG REV: G 2-Debur

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

141 - 1-Issue P/O; 44305 Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Certificate of Conformity is required

142 - Receive & Inspect for Damage & Mat'l Certs

143 - QC6- All purchased or subcontracted products) ***NOTE*** Zinc plating to be done after load test at final assembly.

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release(QC21- Final Inspection - Work Order Release

Job BOM

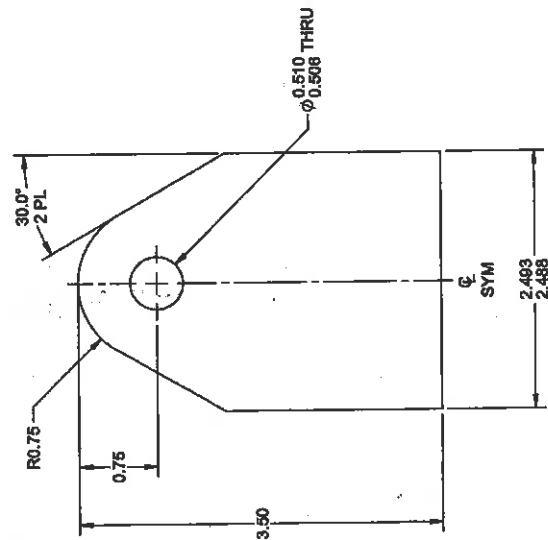
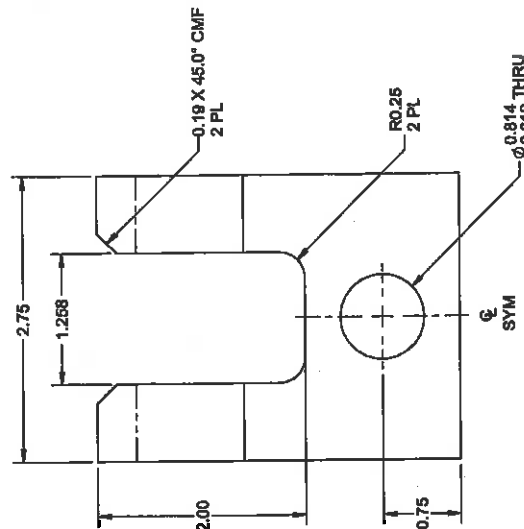
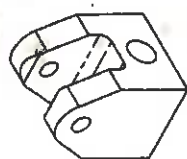
Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-3.000X3.000	AISI 4140 STEEL PLATE OR SHEET, 3.000" X 3.000"	4.5000 ft (3 ea)	100-Bandsaw - 1	S194041 - 8 pcs 2.938 S201997 6 pcs 1.812

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MT-4140-S-3.000X3.000	5	3	0

Part Specifications	
Specifications could not be found.	

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RB T102137-107-109 CLEVIS

- NOTES:
- 1) MATERIAL: 4140
 - 2) HEAT TREAT: 32-38 RC
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: XX = ± 0.1 / ± 0.1
XXX = ± 0.01 / ± 0.1
XXXX = ± 0.005 / ± 0.1
XXXXX = ± 0.0005 / ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) DIMENSIONS MUST BE MET AFTER PLATING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197837 MD
190717

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	JFC	RB T102137-107
APPROVED	JFC	TITLE
DATE 07/06/2019		LIFTING TOOL
		SCALE
		NTS
		REV. G
		SHEET 5 OF 6
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044305**



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044305

PO Date: 8/21/19

Due Date: 8/29/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198070	RBW6305G11331-3G-07	Lugs Outsource1 (Outsource process - Heat Treat) 1-Issue P/O Material 4140-4142 RC 30-35 2-Bead blast ****ONLY BEAD BLAST THE HEAD PORTION OF THE PART***** ***Do not blast critical dimension*** Apply light oil to parts after process 3- Certificate of Conformity is required	Firmed	-	8/29/19	36 pcs	0 pcs	36 pcs	\$2.083/pcs	\$74.99
2	196558	RBW6705G02231-3G	Rigging Pin Assembly N3 (Outsource process - Heat Treat) 1-Issue P/O RC: 26-30 Material 01 2-Bead blast Apply light oil to parts after process 3- Certificate of Conformity is required	Firmed	-	8/29/19	10 pcs	0 pcs	10 pcs	\$7.50/pcs	\$75.00

36 x AUG 29 2019

5206536

10 x AUG 29 2019

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PURCHASE ORDER



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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044305



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197837	RB T102137-107-109	Clevis 1-Issue P/O; Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 Apply light oil after process 4-Certificate of Conformity is required	Firmed	-	8/29/19	14 pcs	0 pcs	14 pcs	\$14.7821/pcs	\$206.95
										Grand Total: \$356.94	

14 X AUG 29 2019

5203789

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Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/23/19 3:01 PM Dart.Guerin.Kimberley

Shipping Ticket

Sold To:

1448

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To:

166293

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB044305.				

Quantity	Part No. / Part Name / Part Description	Pounds
----------	---	--------

14 PCS MATERIAL 4140

ANNEAL & HEAT TREAT TO 32-38RC

BEAD BLAST, C OF C, PRT# RB T102137-107-109, JOB# 197837

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Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

Pounds Shipped:

14

55.00

35-38
8-27-19

Order No.: 169427

Shipped Complete

Quantity Shipped:

14.00

Received By:

Date:

Pounds Shipped:

55.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 08/23/2019

Certification

Date: 08/28/2019

Entry Date: 08/23/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB044305

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
14	14 PCS MATERIAL 4140 ANNEAL & HEAT TREAT TO 32-38RC BEAD BLAST, C OF C, PRT# RB T102137-107-109, JOB# 197837	55

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					

Harden rockwell

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Harden ROCKWELL

32.

38.

TESTED AS PER SAMPLING PLAN

ANNEALED AND HEAT TREATED TO 35-38 RC AS PER CUSTOMER

REQUEUST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OR CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformation, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

RECEIVED

AUG 29 2019

DART AEROSPACE LTD.

KEAN SHEPHERD
QUALITY CONTROL

ATLANTIC HEAT TREATING 2001 LTD